

304 .750 X 2.500

Work Order ID 82052

March-22-12 10:35:34 AM

82052

Page 1

Item ID: D3404-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: GHW Lug

Start Date: 22/03/2012 Start Qty: 40.00

40

Cust Item ID:

Required Date: 29/03/2012 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals:

Process Plan: ML5Date: 12/03/22 Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3404

Rev C

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank: 2.750" long

40

0

12/04/04

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per Folio FA555 and Dwg D3404Dwg Rev: C Folio Rev:AA 2-Deburr

OK 12/04/05

40

0

120

0.00

120

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

OK 12/04/05

40

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82052

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Page 2

March-22-12 10:35:34 AM

Item ID: D3404-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: GHW Lug
 Start Date: 22/03/2012 Start Qty: 40.00 ***40*** Cust Item ID:
 Required Date: 29/03/2012 Req'd Qty: 40.00 ***40*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00		B.A 12/04/08		40	0		
Quality Control									
140	Identify as per dwg & Stock Location: <u>W/A</u>	0.00							
140									
Packaging	Memo	0.00							
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

CL 12-4-9 (X.40)

12/4/10 AJ

MF 12-04-09

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Picklist Print

March-22-12 10:35:37 AM

Page 1

Work Order ID: 82052

82052

Parent Item: D3404-1

D3404-1

Parent Item Name: GHW Lug

Start Date: 22/03/2012

Required Date: 29/03/2012

Start Qty: 40.00

Required Qty: 40.00

Comments:

IPP Rev:A05.09.01New issueKJ/JLM

IPP rev B 09.01.28 new geometry rev.C EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304B0.750X2.500

Purchased

No

100

f

26.3500

0.2291

9.646316

M304B0 750X2 500

**

9.667'

LF 12/04/04

304 BAR .750 X 2.50

Location

Loc Qty

Loc Code

MAT050

26.35

120674

26.35

9.667'

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DART AEROSPACE LTD		Work Order:	82052
Description: GHW Lug		Part Number:	D3404-1
Inspection Dwg: D3404	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.510	+0.008/-0.001	Ø.512	✓		SL08	VIEW
R0.65	+/-0.030	R.65	✓		↓	
0.125	+/-0.010	0.130	✓			
0.500	+/-0.010	0.498	✓			
2.14	+/-0.030	2.143	✓			
1.30	+/-0.030	1.303	✓			
R2.30	+/-0.030	R2.30	✓			
1.14	+/-0.030	1.143	✓			
2.58	+/-0.030	2.585	✓			

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>	Prototype Approval:	N/A
Date: 12/04/04	Date: 12/04/08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.04.12	New Issue	KJ/JLM	
B	09.05.04	Dimensions updated per Dwg Rev. C	KJ/DD	<i>[Signature]</i>

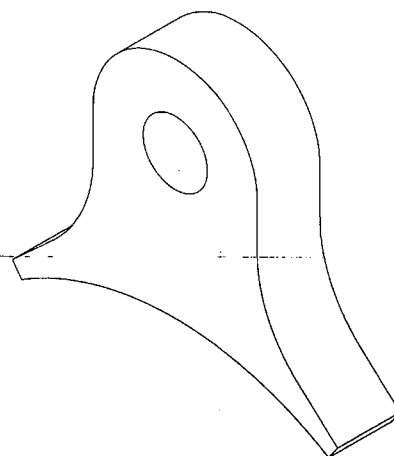
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D3404-1 GHW LUG

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 02052 MCT
 12/03/22

RELEASED
 08/12/18 NW

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR
 PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
 REF. DART SPEC. M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.030 TO 0.060 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.34 lbs

C	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. B6-2, 2.30 RAD WAS 2.13. C7-2 1.14 DIM WAS 1.20.	AJS	08.12.02
B	UPDATE M-SPEC	PH	05.06.14
A	NEW ISSUE	PH	05.03.08
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3404	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		GHW LUG	NTS
DATE	08.12.02	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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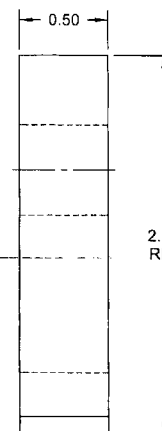
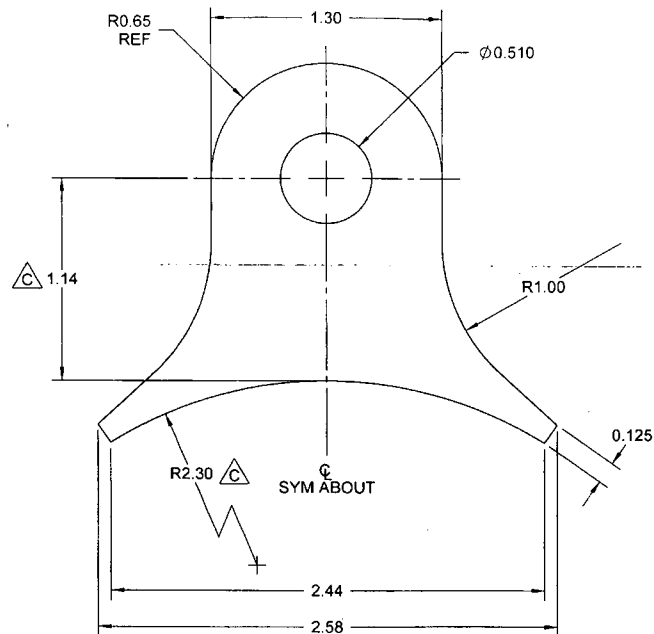
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RELEASED
08/12/18

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DRAWN	AJS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3404	SHEET 2 OF 2
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